

Date: Tuesday, 23/09/2008 9:51:52 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD BLADE FOLD ASSEMBLY
 Job Number : 41290 *2*
 Estimate Number : 13531
 P.O. Number :
 This Issue : 23/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 18/08/2008 Type : SMALL /MED FAB
 Previous Run : 41237
 Written By :
 Checked & Approved By : *mf 08-09-23*
 Comment : Est Rev:A 08-07-30 new issue DD verified by:ec

Part Number : PB674300101
 Drawing Number : B6743001 P.1, 2
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 15/09/2008 Qty: *split 2* Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <i>X</i> Fwd Blade Fold Assembly Weldment batch: <i>42753</i> <i>mf 08-10-30</i>		
2.0	PB674300115	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <i>640608 X 2 41367</i> <i>mf 08-10-24</i>		
3.0	PB674300111	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <i>41365</i> <i>mf 08-10-24</i>		
4.0	PB674300121	PB67-43001-21
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-21 batch: <i>41370</i> <i>mf 08-10-24</i>		
5.0	PB674300123	PB67-43001-23
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-23 batch: <i>41371</i> <i>mf 08-10-24</i>		

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Longitudinal Support Assembly
batch: 41013

MF 08-10-21

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Long T-Handle Assembly
batch: 41581

MF 08-10-21

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Lever Arm
batch: 41411 x 2, 41294 x 1

MF 08-10-21

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Bushing
batch: B40056 B.41373

MF 08-09-23

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bushing
batch: B40062

MF 08-09-23

11.0

D3451048

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Handle and Lock-Down Assembly
batch: B41064 x 2

B41076 x 2

MF 08-10-24

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Handle and Lock-Down Assembly
batch: B41063 x 2

B41279

MF 08-10-24

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Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Square Spacer

batch: B 24416 x 6, B 41351 x 2

mf 08-10-24

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Swing Arm

batch: B 41278 x 8

mf 08-10-24

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Belt Assembly

batch: B 39966 x 2

mf 08-10-24

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: m17850 x 8

mf 08-10-24

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: B 18431

mf 08-10-24

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

SCREW

batch: 18057

mf 08-10-24

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 108701

mf 08-10-24

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Job Number:



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Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

batch: MI 07499

mf 08-10-24

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: MI05077

mf 08-10-24

22.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: MI08473

mf 08-10-24

23.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: MI08986

mf 08-10-24

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPACER

batch: MI08473 X 8

mf 08-10-24

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

batch: MI08473

mf 08-10-24

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Washer

batch: MI0818057

mf 08-10-24

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Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: 108057

YMF 08-10-24

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

batch: 18057

YMF 08-10-24

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: 4085

YMF 08-10-24

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m103962 x4 m101291 x4

YMF 08-10-24

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m107159

YMF 08-10-24

32.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

batch: 19278

YMF 08-10-24

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m105558

YMF 08-10-24

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Seq. #:

Machine Or Operation:

Description :

34.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m104547

mf 08-10-24

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m18180

mf 08-10-24

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

RIVET

batch: m109119 x 10, m10911 m17890 x 6

mf 08-10-24

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

cherry rivet

batch: m104214

mf 08-10-24

38.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

mf 08-10-24

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108991 x 4, m108986 x 4

mf 08-10-24

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

8" LANYARD

batch: m108390

mf 08-10-24

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Description :

41.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

LANYARDS

batch: m108973

mf 08-10-24

42.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

SPRING SLOTTED PIN

batch: m17850

mf 08-10-24

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

SAD

P. M-1/F2
08-10-30

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 (x2)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PM 41184 41183

P. 08/10/30 (2)

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



mf 08-10-30



REV STATUS OF SHEETS	REV SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44
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REVISIONS				
REV	DESCRIPTION	DATE	APPROVED	BY
0	MEG. RELEASE	10/17/95		WJ
45	A CHANGES TO IMPROVE FUNCTIONALITY	3/17/96		WJ
	B WNG AND PZL REVISED AND UPDATED	4/15/96		WJ
	TO REFLECT BELT MODIFICATIONS			
B	CHANGED DIMENSIONS AFTER FIRST	12/16/96		
	FUNCTION TEST CODE TP-D46 (685-1)			

- ▲ SECURE -43 BELT ASSY TO TOP OF -65 FOR -031 OR -43 FOR -033.
LOCATE APPROX AS SHOWN.
- ▲ WITH -137 SLICE IN OPEN POSITION, LOCATE RIVET
APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
- ▲ DRILL WITH -37 AT VERTICAL FULL OPEN POSITION.
DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION,
ASSURING -37 CLEARS ADJACENT STRUCTURE.
- ▲ GRIND AS REQD. USING WASHI4900352J WASHERS.
- ▲ -01 TWO BLADE/OLD ASSY FOR COMMERCIAL VERSIONS ONLY
-02 TWO BLADE/OLD ASSY FOR CANADIAN VERSIONS ONLY

26. TOLERANCE ON DECIMAL, $\pm .1$
27. LAST SECTION LETTER USED - L
28. DRILL NO. 30 (Ø .128) HOLE THRU .37 AND AND .25 (COMPONENT OF .09 ASST). INSERT 80303) SLI PIN, AND GRIND FLUSH WITH .37.

- REFERENCE ONLY

19. PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER W551859 EQUIVALENT.
20. DISERGEAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BIASFOLD ASSY TO AIRCRAFT.

[illegible]

ORIGINAL

REFERENCE ONLY

REFERENCE ONLY